

Work Order ID 144691 -1

*Split*

\*144691\*

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April 21, 2016 4:20:51 PM

Item ID: D205-770-011

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Replacement Engine Mounts

Start Date: 5/13/2016 Start Qty: 2.00

\*2\* *X1*

Cust Item ID:

Required Date: 5/20/2016 Req'd Qty: 2.00

\*2\* *X1*

Customer:

Reference:

Approvals: Process Plan: *MLJ* Date: **APR 22 2016**

Tooling:

Date:

Run Start \*NR1\*

QC: Date: SPC (Y/N):

Date:

Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description                                         | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|------------------------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| <b>Draw Nbr</b>                | <b>Revision Nbr</b>                                              |                      |         |        |              |               |               |                  |                |
| IIN D205-770                   | D                                                                |                      |         |        |              |               |               |                  |                |
| 100                            | Document Control                                                 | 0.00                 |         |        |              |               |               |                  |                |
| <b>*100*</b>                   | DOCUMENT CONTROL                                                 |                      |         |        |              |               |               |                  |                |
| DC                             | Memo                                                             | 0.00                 |         |        |              |               |               |                  |                |
| Doc.Control -USB or Paperwork  | Photocopy bluefile and create labels per PPP D205-770-011 CHG006 |                      |         |        |              |               |               |                  |                |
| 110                            | Pick Kit                                                         | 0.00                 |         |        |              |               |               |                  |                |
| <b>*110*</b>                   |                                                                  |                      |         |        |              |               |               |                  |                |
| Packaging                      | Memo                                                             | 0.00                 |         |        |              |               |               |                  |                |
| Packaging                      |                                                                  |                      |         |        |              |               |               |                  |                |
| 120                            | QC4- 100% Inspect kits for completeness                          | 0.00                 |         |        |              |               |               |                  |                |
| <b>*120*</b>                   |                                                                  |                      |         |        |              |               |               |                  |                |
| QC                             | Memo                                                             | 0.06                 |         |        |              |               |               |                  |                |
| Quality Control                | ***VERIFY ASSEMBLY OF TRIPOD***                                  |                      |         |        |              |               |               |                  |                |

*X* **DAS 28 9-89** **SEP 12 2016**

*2* **DAS 28 9-89** **MAY 18 2016**

*2X* **DAS 28 9-89** **SEP 12 2016**

# Work Order ID 144691

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Item ID: D205-770-011 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Replacement Engine Mounts  
 Start Date: 5/13/2016 Start Qty: 2.00 **\*2\*** Cust Item ID:  
 Required Date: 5/20/2016 Req'd Qty: 2.00 **\*2\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                                                  | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|---------------------------------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130                            | Packaging                                                                 | 0.00                 |         |        |              |               |               |                  |                |
| <b>*130*</b>                   |                                                                           |                      |         |        |              |               | 28            |                  |                |
| Packaging                      | Memo                                                                      | 0.00                 |         |        |              |               | 9-89          |                  |                |
| Packaging                      | Identify and pack for shipping as per RPP D205-770-011<br>Location: FG028 |                      |         |        |              |               |               |                  | SEP 12 2016    |
| 140                            | QC21- Final Inspection - Work Order Release                               | 0.00                 |         |        |              |               |               |                  |                |
| <b>*140*</b>                   |                                                                           |                      |         |        |              |               |               |                  |                |
| QC                             | Memo                                                                      | 0.20                 |         |        |              |               |               |                  |                |
| Quality Control                |                                                                           |                      |         |        |              |               |               |                  |                |

kl SH SEP 12 2016

# Picklist Print

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Work Order ID: 144691

**\*144691\***

Parent Item: D205-770-011

**\*D205-770-011\***

Parent Item Name: Replacement Engine Mounts

Start Date: 5/13/2016

Required Date: 5/20/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A new issue ECN1165p 08-03-31 DD verified by:EC IPP REV:B  
11.12.05 PER ECN11-676 DD VERF:EC IPP REV:C 13.01.24  
PER ECN12-693 DD VERF:JLM

| Component Item ID/<br>Item Name                              | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty    | Qty<br>Issued | Date<br>Issued | Status      |
|--------------------------------------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|-----------------|---------------|----------------|-------------|
| D3684-043<br><b>*D3684-043*</b><br>Mount Assembly            |                        | Manufactured  | No          |                     |                  | 110             | Each               | 1.0000         | 1           | 2               |               |                |             |
|                                                              |                        |               |             |                     |                  |                 |                    |                | **          | 1.2508          |               |                | DAS 26 9-89 |
|                                                              |                        |               |             | <u>Location</u>     |                  |                 |                    | <u>Loc Qty</u> |             | <u>Loc Code</u> |               |                |             |
|                                                              |                        |               |             | ST232               |                  |                 |                    | 1              |             |                 |               |                |             |
|                                                              |                        |               |             | 137083              |                  |                 |                    | 1              |             |                 |               |                |             |
| D3684-045<br><b>*D3684-045*</b><br>Inboard Leg Assembly      |                        | Manufactured  | No          |                     |                  | 110             | Each               | 0.0000         | 1           | 2               |               |                |             |
|                                                              |                        |               |             |                     |                  |                 |                    |                | **          | 10/5219         |               |                | DAS 26 9-89 |
| D3685-041<br><b>*D3685-041*</b><br>Bipod Mount Assembly      |                        | Manufactured  | No          |                     |                  | 110             | Each               | 0.0000         | 1           | 2               |               |                |             |
|                                                              |                        |               |             |                     |                  |                 |                    |                | **          | 144846          |               |                | DAS 26 9-89 |
| D3686-041<br><b>*D3686-041*</b><br>Monopod Assembly          |                        | Manufactured  | No          |                     |                  | 110             | Each               | 2.0000         | 1           | 2               |               |                |             |
|                                                              |                        |               |             |                     |                  |                 |                    |                | **          |                 |               |                | DAS 26 9-89 |
|                                                              |                        |               |             | <u>Location</u>     |                  |                 |                    | <u>Loc Qty</u> |             | <u>Loc Code</u> |               |                |             |
|                                                              |                        |               |             | ST231a              |                  |                 |                    | 2              |             |                 |               |                |             |
|                                                              |                        |               |             | 140657              |                  |                 |                    | 2              |             |                 |               |                |             |
| HL32PB8-14<br><b>*HI 32PB8-14*</b><br>Replacement Hi-Lok Pin |                        | Purchased     | No          |                     |                  | 110             | Each               | 111.0000       | 2           | 4               |               |                |             |
|                                                              |                        |               |             |                     |                  |                 |                    |                | **          |                 |               |                | DAS 26 9-89 |
|                                                              |                        |               |             | <u>Location</u>     |                  |                 |                    | <u>Loc Qty</u> |             | <u>Loc Code</u> |               |                |             |
|                                                              |                        |               |             | ST562               |                  |                 |                    | 111            |             |                 |               |                |             |
|                                                              |                        |               |             | m128179             |                  |                 |                    | 1              |             |                 |               |                |             |
|                                                              |                        |               |             | m128454             |                  |                 |                    | 70             |             |                 |               |                |             |
|                                                              |                        |               |             | m134180             |                  |                 |                    | 40             |             |                 |               |                |             |

# Picklist Print

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Work Order ID: 144691

**\*144691\***

Parent Item: D205-770-011

**\*D205-770-011\***

Parent Item Name: Replacement Engine Mounts

Start Date: 5/13/2016

Required Date: 5/20/2016

Start Qty: 2.00

Required Qty: 2.00

HL86-8

Purchased

No

110

Each

106.0000

2 4

**\*HI 86-8\***

Collar

\*\*

DAS  
28  
9-89

DAS  
28  
9-89

Location

Loc Qty

Loc Code

ST562

106

m131803

86

m134180

20

ax

4

13-420

Purchased

No

110

Each

21.0000

1 2

**\*13-420\***

Piloted Drill

\*\*

DAS  
28  
9-89

DAS  
28  
9-89

Location

Loc Qty

Loc Code

st574

21

124728

21

ix

2

44-300

Purchased

No

110

Each

16.0000

1 2

**\*44-300\***

Step Reamer

\*\*

DAS  
28  
9-89

DAS  
28  
9-89

Location

Loc Qty

Loc Code

ST582

16

124728

16

ix

2

MAY

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Shop Packet Print

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# Work Order ID 144691

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**\*144691\***

Page 1

Item ID: D205-770-011

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Engine Mounts

Start Date: 5/13/2016 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 5/20/2016 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: APR 22 2016

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                                         | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|------------------------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| <b>Draw Nbr</b>                | <b>Revision Nbr</b>                                              |                      |         |        |              |               |               |                  |                |
| IIN D205-770                   | D                                                                |                      |         |        |              |               |               |                  |                |
| 100                            | Document Control                                                 | 0.00                 |         |        |              |               |               |                  |                |
| <b>*100*</b>                   | DOCUMENT CONTROL                                                 |                      |         |        |              |               |               |                  |                |
| DC                             | Memo                                                             | 0.00                 |         |        |              |               |               |                  |                |
| Doc.Control -USB or Paperwork  | Photocopy bluefile and create labels per PPP D205-770-011 CHG006 |                      |         |        |              |               |               |                  |                |
|                                |                                                                  |                      |         |        |              |               |               |                  |                |
| 110                            | Pick Kit                                                         | 0.00                 |         |        |              |               |               |                  |                |
| <b>*110*</b>                   |                                                                  |                      |         |        |              |               |               |                  |                |
| Packaging                      | Memo                                                             | 0.00                 |         |        |              |               |               |                  |                |
| Packaging                      |                                                                  |                      |         |        |              |               |               |                  |                |
|                                |                                                                  |                      |         |        |              |               |               |                  |                |
| 120                            | QC4- 100% Inspect kits for completeness                          | 0.00                 |         |        |              |               |               |                  |                |
| <b>*120*</b>                   |                                                                  |                      |         |        |              |               |               |                  |                |
| QC                             | Memo                                                             | 0.06                 |         |        |              |               |               |                  |                |
| Quality Control                | ***VERIFY ASSEMBLY OF TRIPOD***                                  |                      |         |        |              |               |               |                  |                |

MLJ

MAY 10 2016

2

MAY 10 2016

DAS  
28  
9-89**4. WEIGHT AND BALANCE**

The following is the net weight increase associated with the D205-770-011 Kit.

| Installation                 | Weight  | LATERAL |             | LONGITUDINAL |            |
|------------------------------|---------|---------|-------------|--------------|------------|
|                              |         | Arm     | Moment      | Arm          | Moment     |
| D205-770-011                 | 14.6 lb | -3.5 in | -51.1 in-lb | 190.0 in     | 2774 in-lb |
| Replacement Engine Mount Kit | 6.62 kg | -0.09 m | -0.6 m-kg   | 4.83 m       | 31.97 m-kg |

**5. PARTS LIST**

| Qty<br>-011 | Part Number  | Description                                 |
|-------------|--------------|---------------------------------------------|
| X           | D205-770-011 | REPLACEMENT ENGINE MOUNT KIT                |
| 1           | D3684-043    | MOUNT ASSEMBLY                              |
| 1           | D3684-045    | INBOARD LEG ASSEMBLY                        |
| 1           | D3685-041    | BIPOD MOUNT ASSEMBLY                        |
| 1           | D3686-041    | MONOPOD ASSEMBLY                            |
| 2           | HL32PB8-14   | HI-LOK PIN                                  |
| 2           | HL86-8       | HI-LOK COLLAR                               |
| 1           | 13-420       | PILOTED DRILL (0.2314 dia. w/ 0.2158 pilot) |
| 1           | 44-300       | STEP REAMER (0.2470 dia. w/ 0.2314 pilot)   |

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Revision: **D**  
Date: 12.12.12